

Work Order ID 132861

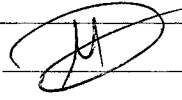
Tuesday, May 12, 2015 3:24:23 PM

132861

Page 1

Item ID: D3536-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Forward
 Start Date: 5/12/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 5/14/15 Req'd Qty: 30.00 ***30*** Customer:

Reference:

Approvals: Process Plan:  Date: 15-5-11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100 FLOW WATER JET 0.00
100 (29) _____ DA 15/05/13
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 (29) _____ DA 15/05/13
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120 (29) _____ DAS 38 9-89
 QC Memo 0.00
 Quality Control

MAY 13 2015

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Page 2

Item ID: D3536-13

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Forward

Start Date: 5/12/15

Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/14/15

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FP001

0.00

130

Packaging

Memo

0.00

Packaging

LOCATION : FP001

DAS
6
9-89

MAY 13 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5

MAY 13 2015

MF
15-5-13

Picklist Print

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Work Order ID: 132861

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Parent Item: D3536-13

D3536-13

Parent Item Name: Gasket Forward

Start Date: 5/12/15

Required Date: 5/14/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	414.4000	0.8269	28			
MNEO60S 063									**				
NEOPRENE SHEET 0.063													

Location

Loc Qty

Loc Code

MAT052

414.4

M130840

58.2

M131990

356.2

30

DART AEROSPACE LTD		Work Order:	132861
Description: Gasket		Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90			Tape	
29.40	+/-0.030	29.40			V-D-02	
27.40	+/-0.030	27.40				
23.90	+/-0.030	23.90				
18.98	+/-0.030	18.90				
14.07	+/-0.030	14.07				
9.15	+/-0.030	9.15				
5.65	+/-0.030	5.65				
3.90	+/-0.030	3.90				
8.00	+/-0.030	8.00				
14.00	+/-0.030	14.00				
20.00	+/-0.030	20.00				
1.89	+/-0.030	1.89				
0.30	+/-0.030	.305				
0.30	+/-0.030	.305				
Ø0.19	+0.005/-0.001	Ø.19				

Measured by:	DL	Audited by:	DAS	Prototype Approval:	N/A
Date:	15/05/13	Date:	30 9-89	Date:	N/A

MAY 13 2015

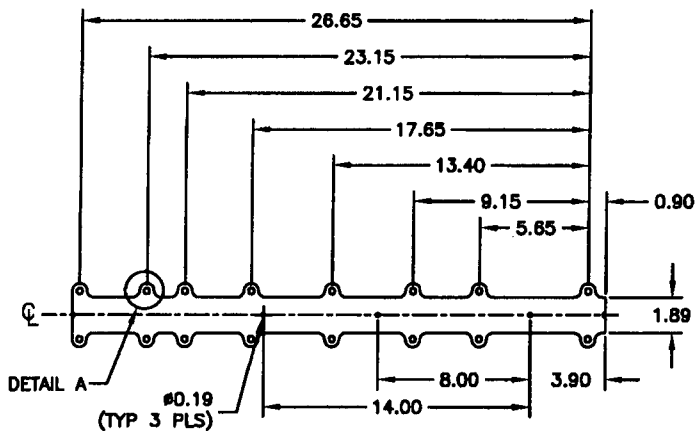
Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

DART

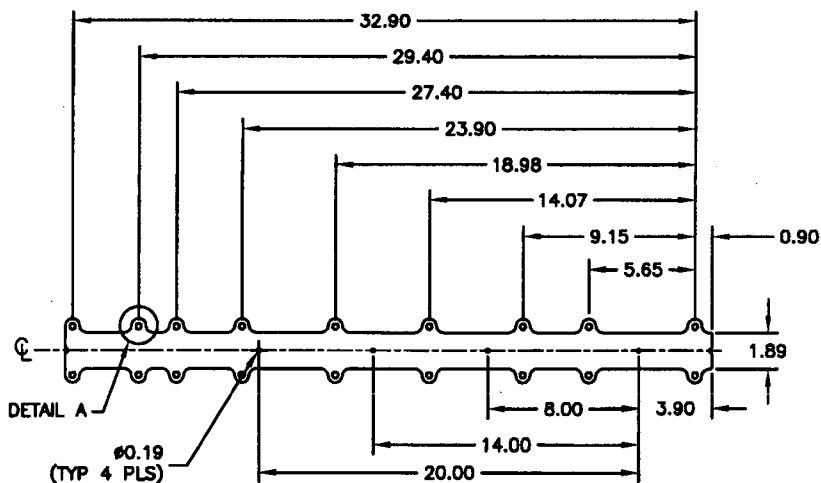
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04.02.12-11

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE
				1:10



D3536-11 GASKET



D3536-13 GASKET

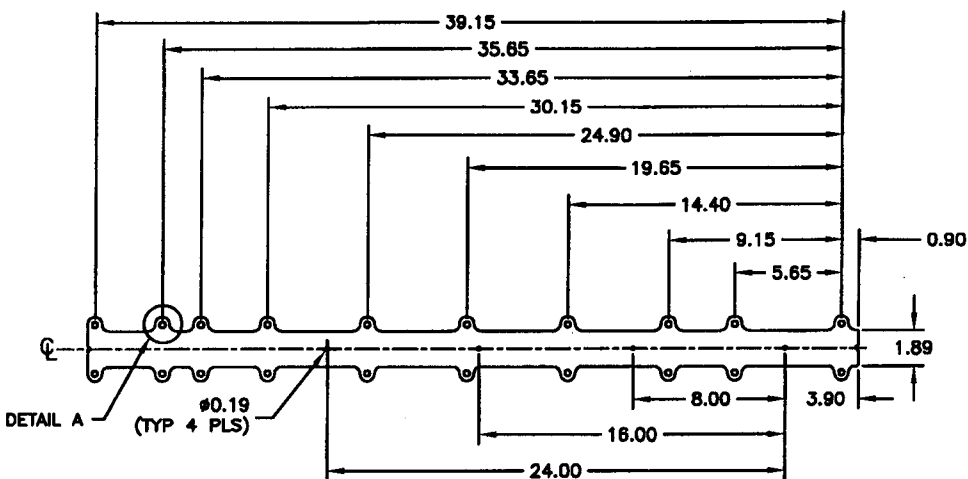
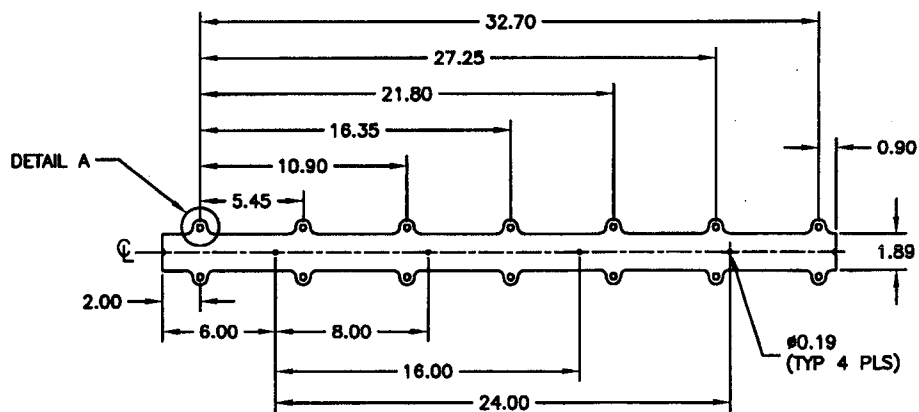
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

04.02.12-11

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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

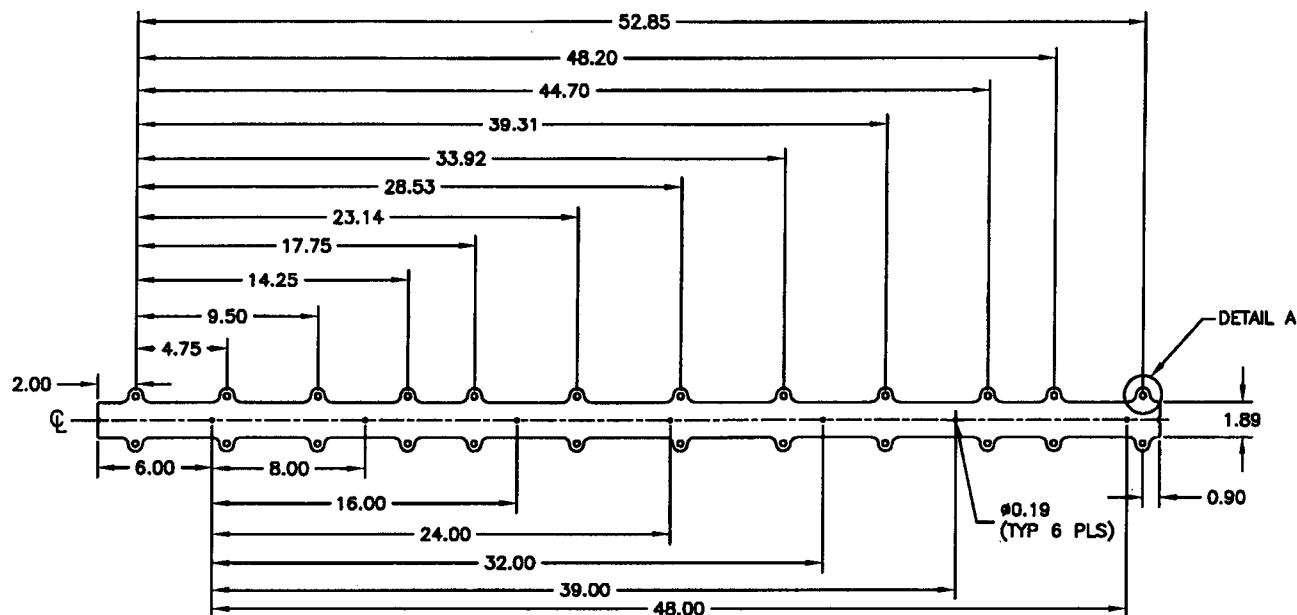
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0702.12**D3536-15 GASKET****D3536-21 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

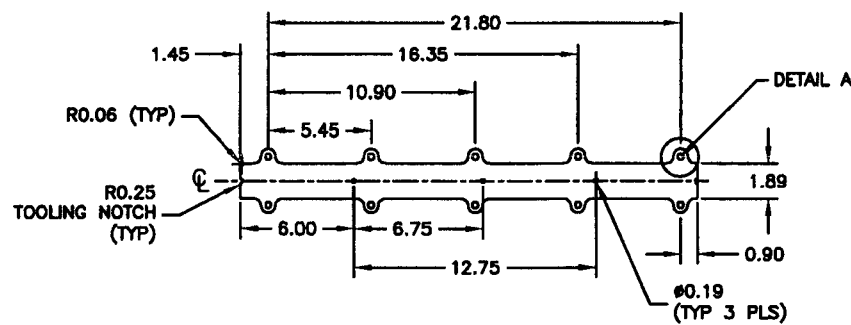
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
				SCALE 1:10

RELEASED
07.02.17



D3536-23 GASKET



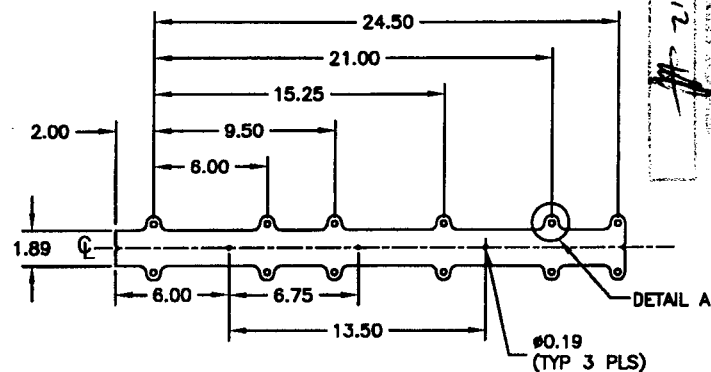
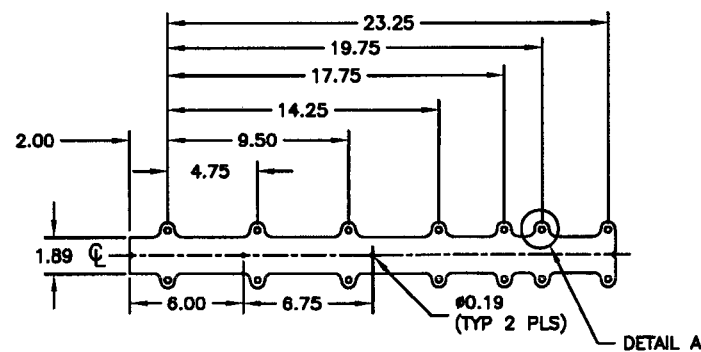
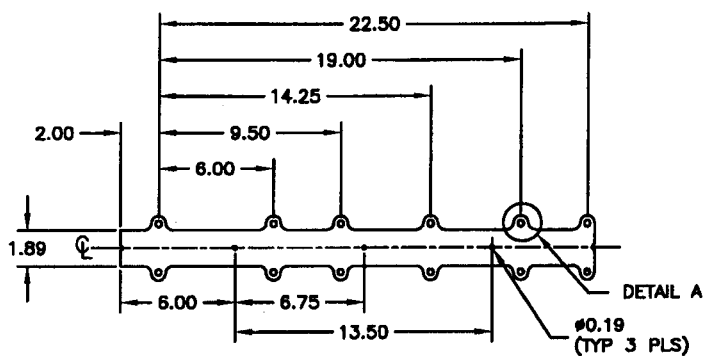
D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

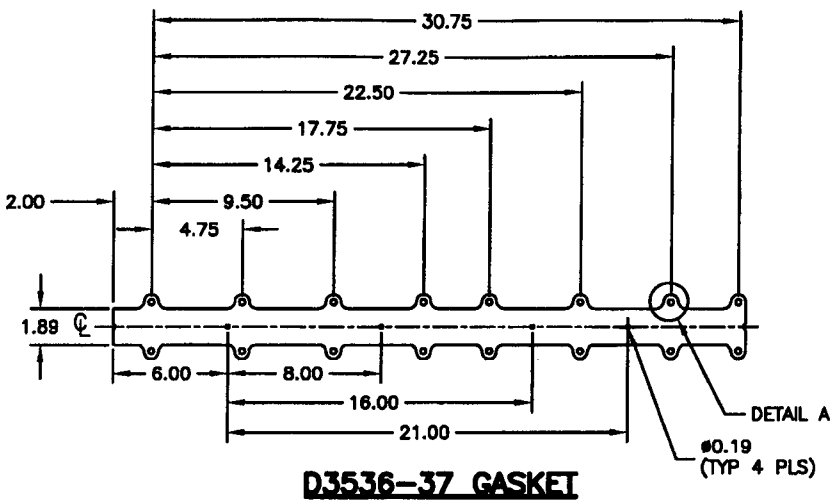
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CHECKED	AH	APPROVED	AH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE
				1:10

RELEASED
07.02.12**D3536-33 GASKET****D3536-35 GASKET****D3536-31 GASKET****NOTES**

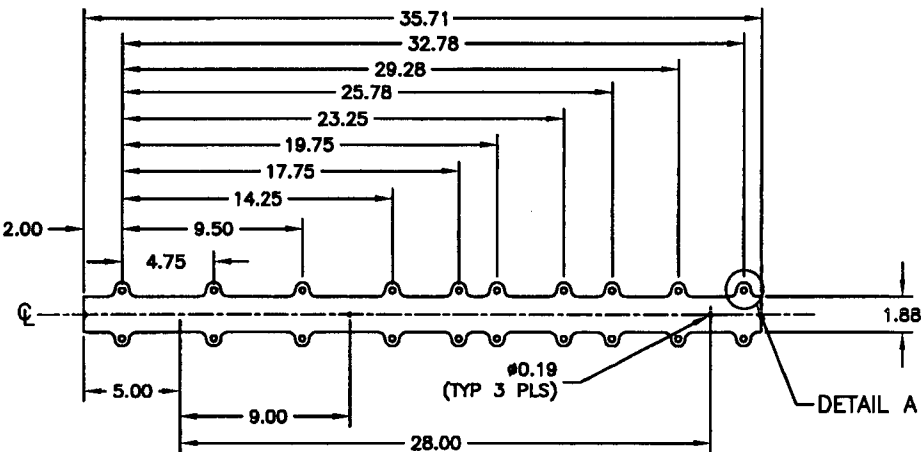
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. & SHEET 5 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10



D35.36-37 GASKET



D3536-39 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
- 7) SEE PAGE 8 FOR DETAILS AND SECTION

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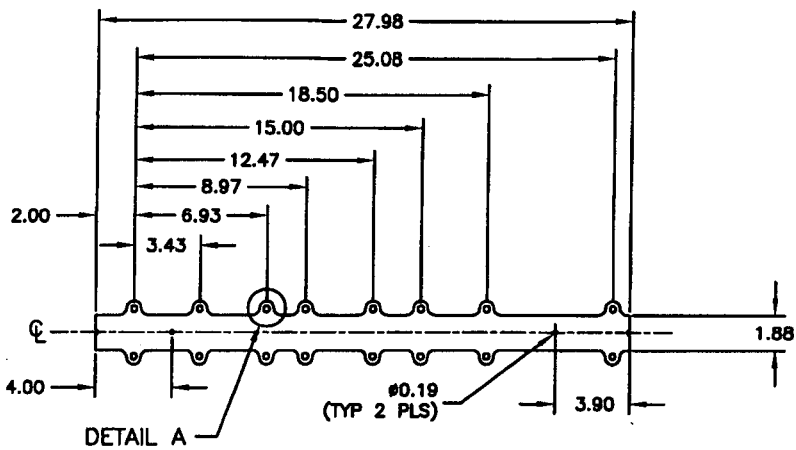
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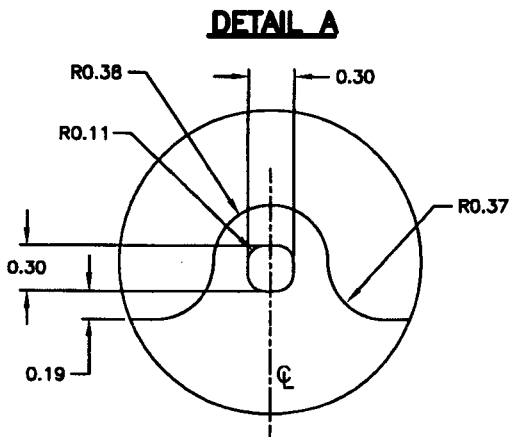
DART

070212 *AK*

DESIGN	C B	DRAWN BY	C B	DART AEROSPACE USA, INC.	
CHECKED	AH	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3536
DATE	06.10.25			TITLE	GASKET
				REV. A	SHEET 6 OF 6
				SCALE	1:10



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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